

Date: Monday, 10/11/2008 3:35:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 43294 ²	
Estimate Number : 11403	
P.O. Number :	Part Number : D3296041
This Issue : 10/11/2008 S.O. No. :	Drawing Number : D3296 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 41797	Material :
Written By :	Due Date : 21/11/2008
Checked & Approved By : <u>JUD 08-11-11</u>	Qty: <u>10</u> Um: Each
Comment : Est. C 05.10.14 Added step 14 KJ/EC Est Rev:D Revised Steps 06-11-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	<u>B39774</u>

(4)

(6)

B42030

SP

2.0	D32963	Door Panel
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3 Door Panel		<u>B39745</u>

(6)

(4)

42031

SP

3.0	D31617	Hinge 14.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Hinge 14"

Batch: B41806

4.0	D31619	Hinge 17.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Hinge 17"

Batch: 41807

8/11/24 SP

43314

8/11/19

SP

(10x)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/11/2008 3:35:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43294

Part Number: D3296041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total : 250.0000 Each(s)

Rivet, Universal Head

Batch: M109545

SP

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Fabricate & assemble as per Dwg D3296.

FF 08/11/25

(10)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

500/11/25 (40)

8.0 POWDER COATING POWDER COATING



M105642



(10X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 10:00

OVEN TEMPERATURE: 320 OF

FINISH TIME: 10:30

M-1 08/11/26

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08/11/26 (10)

10.0 D2137 Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Decal - No Step

Pick:

Qty	Part Number	Description	Batch
1	D2137	Decal	B343312

SP

11.0 D2419 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Handle

Pick:

Qty	Part Number	Description	Batch
1	D2419	Handle	B42100

8/11/19

(10X)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43294

Part Number: D3296041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D2462	Seal
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Comment: Qty.: 0.3333 f(s)/Unit Total : 3.3330 f(s)

Qty	Part Number	Description	Batch
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1	D2462	Seal	B37747
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CUT ONE PIECE 4.00" LONG

SP

13.0	D2462	Seal
------	-------	------



Comment: Qty.: 0.4420 f(s)/Unit Total : 4.4200 f(s)

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2462	Seal	B37747
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CUT ONE PIECE 5.30" LONG

SP

14.0	D2462	Seal
------	-------	------



Comment: Qty.: 2.0420 f(s)/Unit Total : 20.4200 f(s)

Qty	Part Number	Description	Batch
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1	D2462	Seal	B37747
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CUT ONE PIECE 24.50" LONG

SP

15.0	D27281	Dart Logo Label - small
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Dart Logo label small

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2728-1	Decal	B39012
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SP

16.0	AN960JD6	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	AN960JD6	Washer	M6085
---	----------	--------	-------

8/11/19

10x

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 43294

Part Number: D3296041

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 MS20470AD46 Rivet, Universal Head



10x

Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet

M108377

8/11/19

SP

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

FF 08/11/27 (9)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/11/27 (9)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57217

8/11/27 (9)

21.0 QC21 FINAL INSPECTION/W/O RELEASE



08/11/28

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

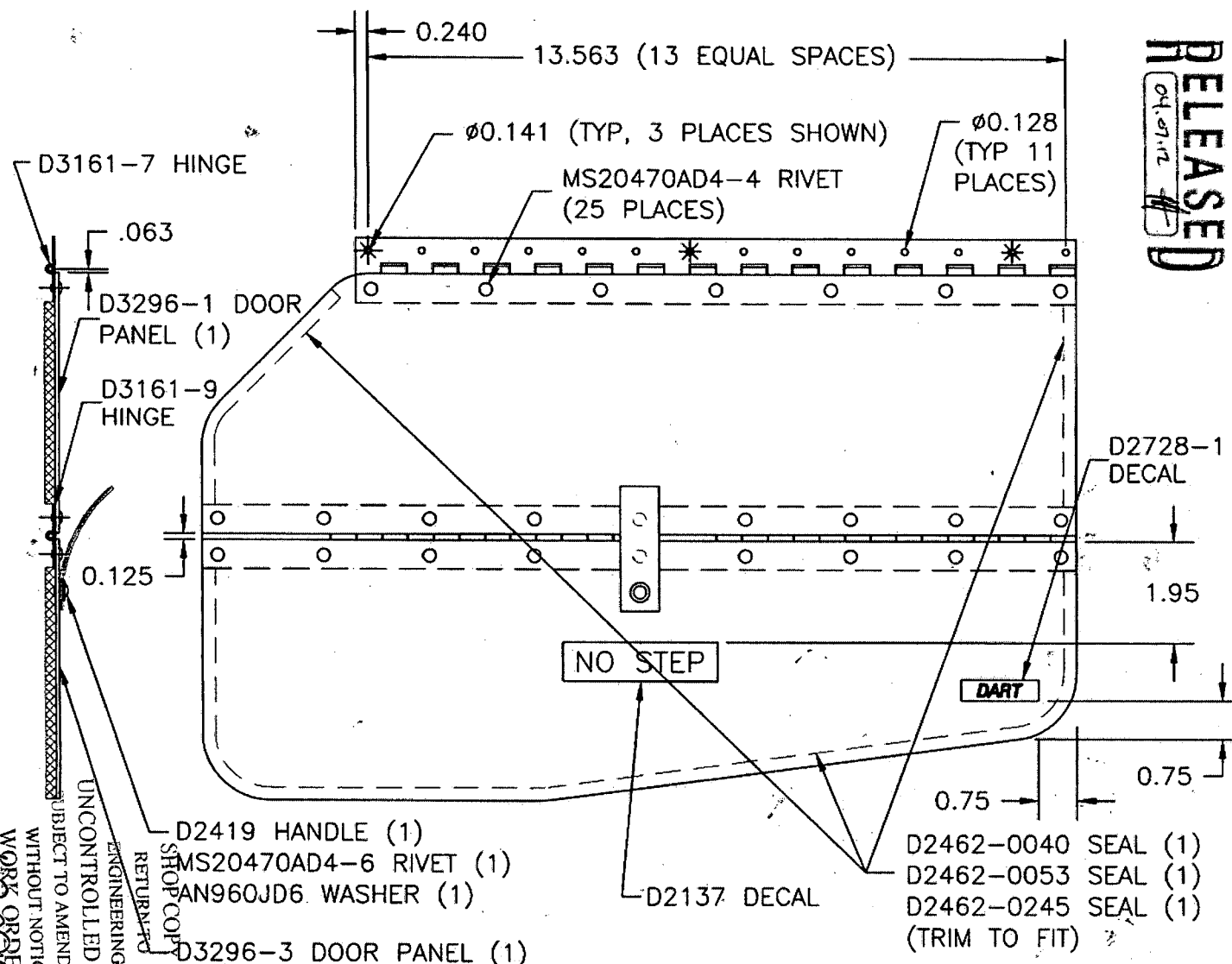
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. A
DATE 04.06.28		D3296	1 OF 2
		TITLE	SCALE
		DOOR ASSEMBLY	1:3
A	04.06.28	NEW ISSUE	

RELEASED
04.07.12

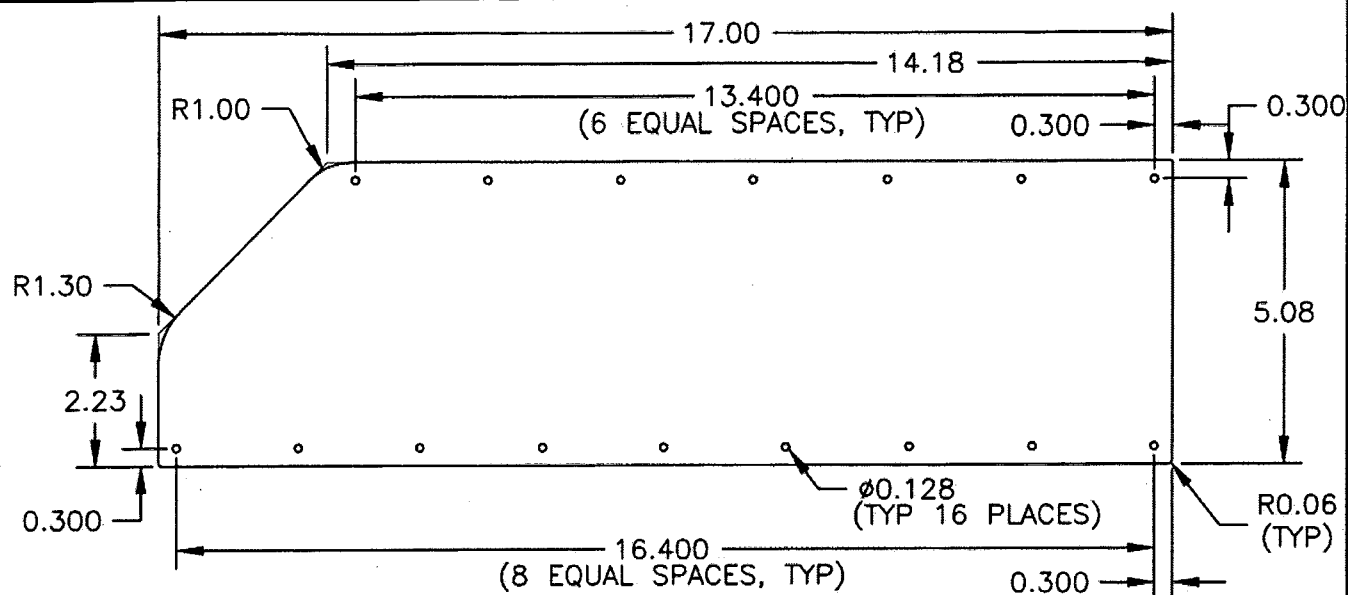


D3296-041 DOOR ASSEMBLY

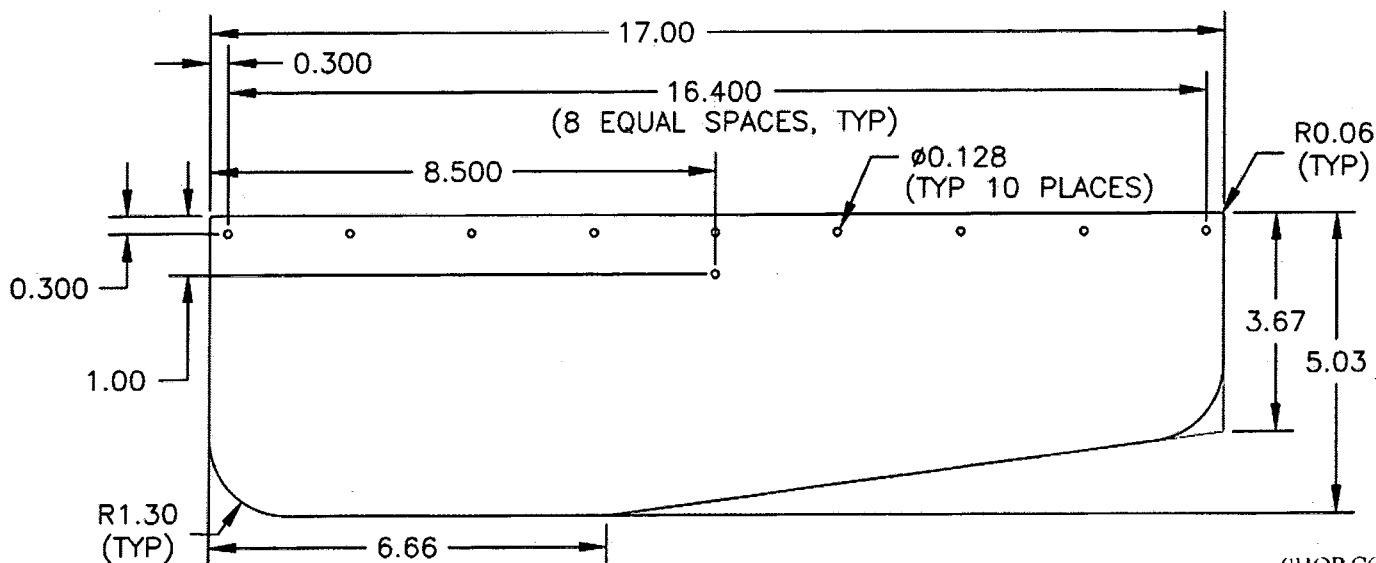
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43294

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